ABSTRACT OF THE DISCLOSURE

It is strongly demanded that a stable thread machining process be attained by carrying out a thread machining operation while varying the rotational frequency of a spindle, and thereby restraining the occurrence of cutting chatter. According to the present invention, in which a thread machining process is carried out on the basis of a rotation of the spindle and a movement of a feed axis, the above-mentioned demand is met by executing the steps of determining a relative phase error of the spindle positions and feed axis during a thread machining operation, and determining a movement quantity of the feed axis on the basis of a pseudo spindle position set by error-compensating the quantity of the relative phase error with respect to the spindle position.